

Date: Friday, 22/08/2008 10:03:52 AM
User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SADDLE FITTING, AFT (OUTBOARD/INBOARD)
Job Number :	41589		
Estimate Number :	10533		
P.O. Number :		Part Number :	D2573
This Issue :	22/08/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2573 REV E
First Issue :	/ /	Project Number :	N/A
Previous Run :	40516	Drawing Revision :	E
	Type :	Material :	
	MACHINED PARTS	Due Date :	12/09/2008
Written By :		Qty:	10
Checked & Approved By :	<u>JUL 08-8-22</u>	Um:	Each
Comment :	Est: 1 As Per RevE 06-01-27 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101007	Saddle Billet
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)
7075-T7351 8.25X7.75X2.5
Make from D6101-007 billet for D2573
Ensure that grain is along 7.75" length
Batch No: 34875

SS 08/09/12 (10)

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
Program Batch No. 41589 Double check by: *ml*

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
4-Deburr and remove all machining marks
5-Tumble to remove sharp edges.

ml / SS 08/09/12 (10)

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
Machine keyway as per dwg D2573 & D2574

ml / SS 08/09/12

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml / SS 08/09/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 22/08/2008 10:03:52 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 41589

Part Number: D2573

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.L 08/08/16

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-L 08/09/17

10X

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M108523

START TIME:

1:00pm

OVEN TEMPERATURE:

320°C

FINISH TIME:

1:30pm

9H 08-09-17

X(10)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

P 8/9/18 (10)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

5433

P 8/9/18 (10)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/18

Job Completion



12 08.09.18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 41589
Description: Saddle, Aft Outboard		Part Number: D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.439	.439	.439	.439		
B	1.745	1.755		1.750	1.749	1.750	1.749		
C	3.495	3.505		3.506	3.499	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.749		
E	7.990	8.010		7.998	8.000	7.999	7.999		
F	0.490	0.510		.501	.503	.505	.504		
G	0.257	0.262		.259	.259	.259	.259		
H	0.375	0.380		.378	.377	.377	.377		
I	0.490	0.510		.494	.506	.501	.500		
J	1.174	1.184		1.178	1.179	1.180	1.179		
K	0.558	0.578		.565	.574	.568	.569		
L	1.174	1.184		1.178	1.179	1.180	1.179		
M	1.365	1.375		1.369	1.372	1.369	1.369		
N	2.495	2.505		2.500	2.500	2.500	2.499		
O	4.119	4.129		4.121	4.123	4.122	4.121		
P	0.115	0.135		.118	.126	.127	.127		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.246	.253	.252	.252		
S	0.115	0.135		.117	.132	.131	.122		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.228	3.230	3.230	3.230		
V	0.230	0.250		.230	.242	.240	.240		
W	0.115	0.135		.118	.129	.129	.127		
X	0.308	0.313		.311	.311	.312	.311		
Y	0.760	0.765		.760	.761	.760	.760		
Z	0.352	0.372		.366	.367	.367	.367		
AA	0.470	0.530		.506	.506	.506	.500		
AB	0.615	0.635		.623	.637	.633	.632		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.240	.247	.246	.246		
AE	1.500	1.520		1.512	1.511	1.512	1.512		
AF	0.115	0.135		.120	.122	.122	.120		
AG	0.240	0.280		.265	.260	.260	.260		
AH	0.240	0.260		.240	.251	.249	.249		
AI	2.000	2.020		2.000	2.000	2.001	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	JML
Date:	08/09/15

Audited by:	JL
Date:	08/09/16

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order: 41589
Description: Saddle, Aft Outboard	Part Number: D2573
Inspection Dwg: D2573 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				15	16	17	18		
A	0.438	0.443		.439	.439	.439	.437		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.509	.503	.502	.502		
G	0.257	0.262		.260	.259	.259	.259		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.500	.500	.501	.501		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.568	.568	.568	.570		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.369	1.369	1.368		
N	2.495	2.505		2.498	2.500	2.500	2.500		
O	4.119	4.129		4.122	4.123	4.121	4.122		
P	0.115	0.135		.127	.127	.127	.127		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.252	.251	.251	.253		
S	0.115	0.135		.126	.126	.127	.127		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		.240	.238	.238	.238		
W	0.115	0.135		.129	.128	.127	.126		
X	0.308	0.313		.310	.311	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.367	.367	.367	.367		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.632	.632	.634	.639		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.247	.248	.250	.247		
AE	1.500	1.520		1.514	1.514	1.514	1.514		
AF	0.115	0.135		.129	.128	.128	.126		
AG	0.240	0.280		.265	.269	.267	.266		
AH	0.240	0.260		.249	.248	.248	.248		
AI	2.000	2.020		2.002	2.001	2.001	2.001		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	One 188
Date:	08/09/15 / 08/09/16

Audited by:	JL
Date:	08/09/16

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
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DART AEROSPACE LTD	Work Order: 41589
Description: Saddle, Aft Outboard	Part Number: D2573
Inspection Dwg: D2573 Rev. E	Page 1 of 1

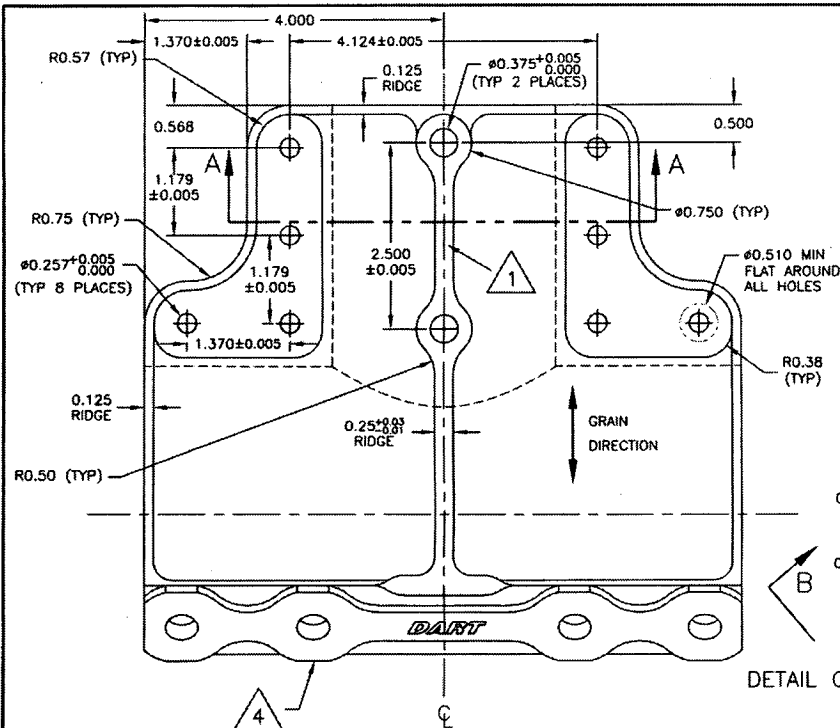
Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				19	210	3	4		
A	0.438	0.443		.443	.443				
B	1.745	1.755		1.750	1.750				
C	3.495	3.505		3.500	3.500				
D	1.745	1.755		1.750	1.750				
E	7.990	8.010		8.002	8.003				
F	0.490	0.510		.510	.505				
G	0.257	0.262		.259	.258				
H	0.375	0.380		.377	.376				
I	0.490	0.510		.503	.503				
J	1.174	1.184		1.178	1.178				
K	0.558	0.578		.570	.570				
L	1.174	1.184		1.178	1.178				
M	1.365	1.375		1.370	1.370				
N	2.495	2.505		2.499	2.500				
O	4.119	4.129		4.123	4.123				
P	0.115	0.135		.126	.126				
Q	0.115	0.135		.135	.130				
R	0.240	0.260		.252	.250				
S	0.115	0.135		.125	.126				
T	0.178	0.198		.188	.188				
U	3.210	3.250		3.228	3.230				
V	0.230	0.250		.239	.240				
W	0.115	0.135		.125	.126				
X	0.308	0.313		.311	.311				
Y	0.760	0.765		.760	.760				
Z	0.352	0.372		.360	.360				
AA	0.470	0.530		.500	.500				
AB	0.615	0.635		.625	.625				
AC	0.053	0.073		.063	.063				
AD	0.240	0.260		.248	.252				
AE	1.500	1.520		1.514	1.514				
AF	0.115	0.135		.128	.125				
AG	0.240	0.280		.265	.260				
AH	0.240	0.260		.249	.250				
AI	2.000	2.020		2.002	2.002				
AJ	0.023	0.043		.023	.033				
Accept/Reject									

Measured by: <i>MR J. J.</i>	Audited by: <i>J. J.</i>
Date: 08/09/16	Date: 08/09/16

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
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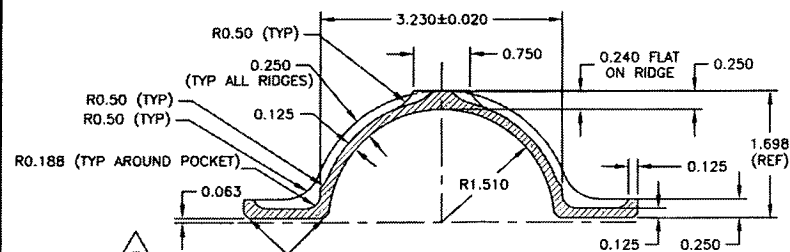
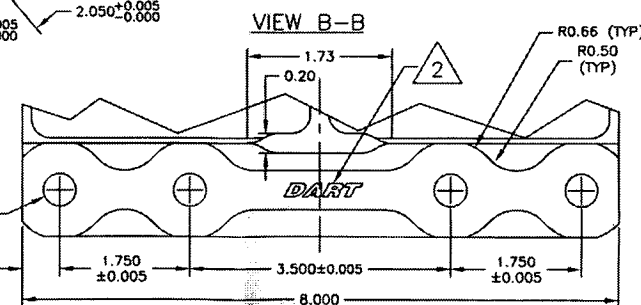
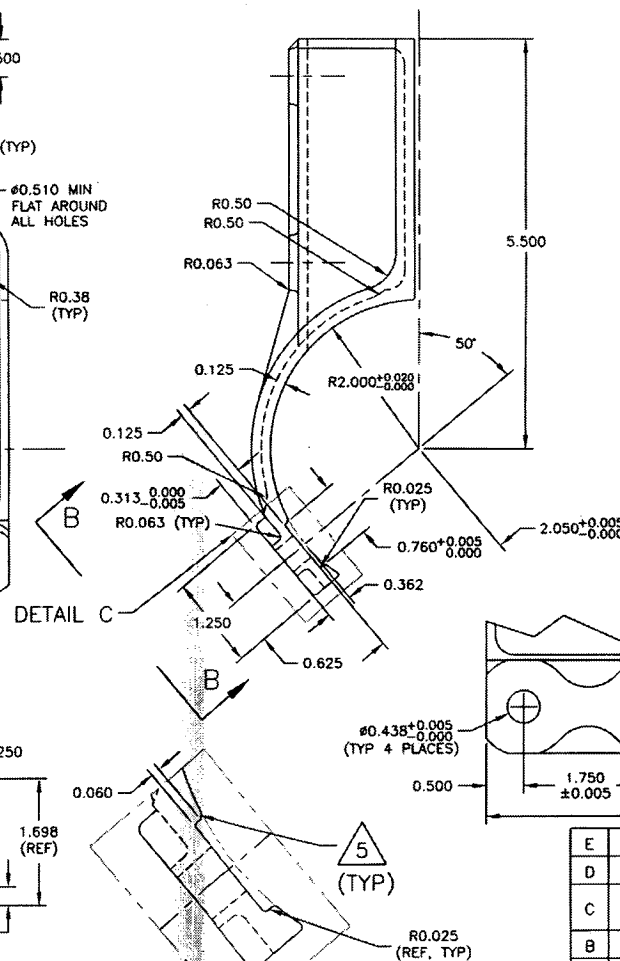
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NOTES




MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-001)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125
- 3 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 4 CHAMFER 0.063" x 45° ALL AROUND
- 5 CHAMFER 0.033" x 45° (SEE DETAIL C)






SECTION A-A

DETAIL C
SCALE 4:3

E	05.07.13	ADD CHAMFER ON RIDGE NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCRP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN		DRAWN BY
DS		PH
CHECKED 		APPROVED 
		
		DART AEROSPACE LTD. HAMMERSLEY, ONTARIO, CANADA
DATE		DRAWING NO.
05.07.13		D2573
		TITLE
		OUTER AFT SADDLE
		SCALE
		2:

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DART AEROSPACE LTD.

DESIGN	DRAWN BY		DART AEROSPACE LTD. HAMMERSLEY, ONTARIO, CANADA
DS	PH		
CHECKED	APPROVED	DRAWING NO.	REV.
		D2573	
DATE	TITLE		SHEET 1 OF
05.07.13	OUTER AFT SADDLE		SCALE

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